User: Prsht Rev. First Issue Previous Run Written By

Tuesday, 7/1/2008 2:35:04 PM

Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 40197 Estimate Number : 10175

P.O. Number

This Issue

: 7/1/2008

: 39805

: NC : 11

S.O. No. :

: MACHINED PARTS Type

Part Number

Drawing Name

Drawing Number

: D2570 D2570 REV B

: BUSHING

Project Number **Drawing Revision**

: N/A : B

Material

Due Date

: 7/21/2008

Qty:

300 Um:

Each

Checked & Approved By

Comment

: Est

Re-format; Removed finishing; Material changeK

EC

est F 07.07.06 rev B dwg

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M303R0750



303 Round Bar .75"



Comment: Qty.:

0.0810 f(s)/Unit Total: 24.2865 f(s)

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

Batch <u>108330</u>

2.0



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA198

Deburr



3.0







Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

QC2

aspoin





Comment: SECOND CHECK

5.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
+			; 5								
		3			·						
Part No	:	PAR #: Fault Category:	NC	R: Yes	No DQ	A:	Date:				
				QA:	N/C Close	d:	Date:				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC		Vifi4i		Τ					
		Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector			
				l à							
					- 1	,					
						·					

NOTE: Date & initial all entries

Date:

Tuesday, 7/1/2008 2:35:05 PM

User:

Kim Johnston

Process Sheet

Y 2 4 1

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40197

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



N 28-27-08

Dart Ae	rospace L	td								
W/O:			WO	RK ORDER C	HANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					6 4					
		3								
		14								
Part No		PAR #:	Fault Categ	ory:	NC	R: Yes	No DQ	A:	Date:	
	100								Date:	
NCR:			WORK ORDE	R NON-CON	ORMANCE	(NCR	.)			
		Description of NC Corrective Action Section B			Verific		ration	Approval	Approval	
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Desc Chief Eng		Sign & Section C			Chief Eng	QC Inspector
				197		:				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40197
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	, ଓଠ\	√			
0.060	+/-0.005	,060	N.			
R0.010	+0.010/-0.000	R.010	J			
Ø0.425	+0.000/-0.002	d.435	\			
Ø0.257	+0.005/=0.000	016, B	J			
Ø0.750	+/-0.010	0 746	$\int_{\mathcal{A}}$			
0.030 x 20°	+/-0.010	.030×90°	J			
						- 10.000
					Mr. 3	

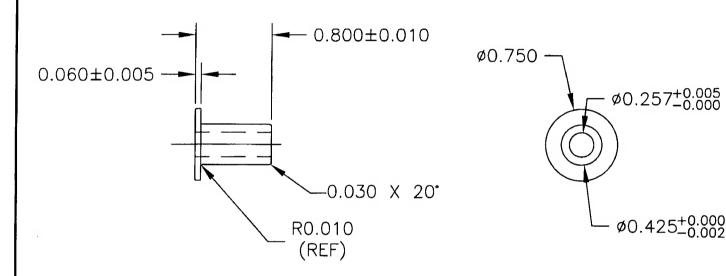
Measured by: mm-/and	Audited by:	Prototype Approval:	N/A
Date: 08/07/6	Date: 08/07/06	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM 🚓	B





DESIG	PH	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED	DRAWING NO. REV. B
	世	H	D2570 SHEET 1 OF 1
DATE			TITLE SCALE
07.0	04.17		BUSHING 1:1
Α		96.09.16	NEW ISSUE
В		07.04.17	UPDATE NOTES



D2570 BUSHING

D2570 BUSHING

MATERIAL:

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

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